Quality Control

											DQA:	Date:	, , , , , , , , , , , , , , , , , , ,
NCR:	Yes	/ No	,	-	•	WORK ORDER NON-C	OI	NFORI	MANCE / UPDATE			 	1
						· ·					QA Closed:	Date:	
Work Ord	er.					DISPOSITION			AGAINS	T DE	PARTMENT	PROCESS	
						Rework			Skid-tube Crosstube	-	]	Water Jet	Engineering
Part	No.					Scrap		1	Machining Small Fal	-	4	d. Eng. Coor.	Quality
						Use-as-is			noforming Finishing	~ ——	Rec/Stor	e/Packaging	Other
NCR	No.					Work Order Update	]		Large Fab Composite	-	]	Supplier	
Root					Descri	ption of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty	(	or Non-conformance	Ch	nief Eng	Description		Date /	Verification	QC Inspector
Doc/Data						**							
Equip/Tooling					Name -				\$ \$ \$ \$.5				
Operator									AND				
Material										-			
Setup													1
Other													
Process													
Supplier							l						
Training													
Unapproved				<u> </u>									
						F	AUL	T CATE	GORY				·
Landi		1				General		1		_	7		٦
	Ш	Bending				Bend		Grain			Ovalized		Pressure/Forced
	<u> </u>	Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa		<u> </u>	Over/Under	<b>—</b>	Temperature/Cure
	L_	Cracks				Broken/Damaged		1	on Incomplete	$\perp$	Part Incorred	<u> </u>	Weld
		Crushed/0	Crimped.			Burrs	$oxed{\bot}$	1	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte			Part Moved		
	Ш	Heat Trea	t			Countersink		Mislabe	led		Positioned V		٦
	1	Inspection	Strip in	Tube		Cut Too Short	1	Misread	1	-	Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord January-18-13	ler ID 95834			*958	3.34*				•	Page
Item ID: Revision ID: Item Name:	D3065-5 Step Leg			Accept	*N900	<b>040</b>	100	<b>*</b> . §	Setup Start Stop	*NS1* *NS2*
Start Date: Required Date Reference:		Qty: 120.00 d Qty: 120.00	*120 *120	•	Cust Item I	D:				14(7)
Approvals:	Process Plan:	•	Date:		•	nte:		F	Run Start Stop	*NR1* *NR2*
Sequence ID/ Work Center I 130 *130* HandFinish Hand Finishing			t per QSI005 4.1	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Qty N	Reject Insp. Number Stamp
*140 *140* QC Quality Control	QC3-1	nspect Part Finish Memo		0.00				95 <sub>x</sub>	-	Bis,
150	<u>Identif</u>	y as per dwg & Stoo	ck Location:	0.00						

95X

0.00

Memo

150

\*150\*
Packaging

Packaging

								DQA:	Date:	
NCR: Ye	s / No			WORK ORDER NON-	CONFOR	RMANCE / U		0.4.01		
								QA Closed:	Date:	
Work Order:	•			DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No NCR No				Rework Scrap Use-as-is Work Order Update	The	Skid-tube  Machining  moforming  Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Description of work order update	Initial	T #	Action	Sign &		
Cause	Date	Step	Qty	or Non-conformance	Chief En	g Des	scription	Date	Verification	QC Inspector
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup		1						i		
Other		<u>.</u>								
Process										
Supplier										
Training								·		1
Unapproved										
				F	<b>AULT CAT</b>	EGORY				
Landing	Gear			General						

Grain

Hardware

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

Pressure/Forced

Weld

Other

Temperature/Cure

Wrong Stock Pulled

Ovalized

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Over/Under tolerance

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Bending

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S

Bend

Burrs

BOM/Route

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Broken/Damaged

<b>Work Ord</b> January-18-13				*958	34*							Page 3
Item ID: Revision ID: Item Name:	D3065-5 Step Leg			Accept	*N900	<b>040</b>	100	<b>)</b> * :	Setup	Start Stop	171	S1* S2*
Start Date: Required Date: Reference:	1/30/13	<b>Start Qty:</b> 120.00 <b>Req'd Qty:</b> 120.00	*12( *12(	-	Cust Item I Customer:	D:						
Approvals:	Process P QC:	lan:	Date:	Tooling:SPC (Y/N):		ite:		]	Run	Start Stop	*N  *N	R1* R2*
Sequence ID/ Work Center I	D	Operation Description	,	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
*160 *160* QC Quality Control	;	QC21- Final Inspection - \( \text{Memo} \)	Nork Order Release	0.00					1 <u>C</u> 3		130 5 1	3-25 3-03-25

			DQ	A:	Date:	ſ
NCR: Yes	/ No	WORK ORDER NON-CONFORMANCE / UPDATE				

											QA Closed.	Date.	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I						Rework Scrap Use-as-is	]       <sub> </sub>	ı	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	No.					Work Order Update	<u> </u>		Large Fab	Composite		Supplier	
Root					Descri	ption of work order update	Initi	al	Acti	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chief	Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other							:					i	
Process											:		
Supplier					,								
Training													
Unapproved							<u> </u>						
<u> </u>						F	AULT C	ATEC	GORY				. 11
Landi	ng (	Gear				General						-	<b>-</b>
		Bending				Bend	Gra	ain			Ovalized		Pressure/Forced
	<u> </u>	Centre No	ot Concer	ntric to	o/s	BOM/Route	Har	rdwai	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	$\vdash$	•	on Incomplete	<b>,</b> —-	Part Incorre	<b>⊢</b>	Weld
		Crushed/0	Crimped.			Burrs	$\vdash$		ions Incomplete/U	Inclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	<u> </u>	Cuffs				Contamination	Mā	ainte	nance		Part Moved		
	L	Heat Trea				Countersink	Mis	slabe	led		Positioned V		7
		Inspection		Tube		Cut Too Short		sread			Power Loss/	Surge	Other
		Ripples in				Drill Holes	<b></b>	set					
,		Torque W	aves in E	xtrusio	n	Drawing	Ou	t of C	alibration				
		Turning So	equence			Finish	Ou	t of S	equence				
		Wave/Tw	ist in Tub	oe .		Folio	I lou	tside	Dimensions				

Page 1

Work Order ID:

95834

Parent Item:

Comments:

D3065-5

Parent Item Name:

Step Leg

IPP: C02.11.01Incorporated D3066-1 IPPKJ/RF

IPP Rev:D Now on Water Jet 06-04-11 JLM

IPP Rev:E Now manufactured with 6061-T6 06-05-25 JLM

**Start Date: 1/30/13** 

Required Date: 1/31/13

Required Qty: 120.00

Start Qty: 120.00

	IPP Rev:E Now	manufactured wit	n 6061-16	) 06-05-25 JL	JM					7			
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080 6061-T6 .080 Sheet		Purchased	No			100	sf	298.0686	0.825	104,21053	තිරු		In 13-2-2
				<b>Location</b>		Loc Oty	<u>Lo</u>	c Code					
				MAT021		298.068632							
				117	285	0.248632							
				119	766	39.82							

168.8

89.2

124572

120096

123279

124572 80 S.F.

									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	CONFOR	RMANCE / UP	PDATE	0.4.01====	Data	
					·	E			QA Closed:	Date:	
Work Orde	r:				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
					Rework		Skid-tube	Crosstube		Water Jet	Engineering
Part N	0.				Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	The	moforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	0				Work Order Update	]	Large Fab	Composite		Supplier	
							,			, · · · · · · · · · · · · · · · · · · ·	
Root				Descri	ption of work order update	Initial	Ad	ction	Sign &		
Cause	Date	Step	Qty	. (	or Non-conformance	Chief En	g Desc	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other		1									
Process			1							]	

Bend Grain Pressure/Forced Bending Ovalized BOM/Route Centre Not Concentric to O/S Over/Under tolerance Temperature/Cure Hardware Broken/Damaged Cracks Inspection Incomplete Part Incorrect Weld Crushed/Crimped. Instructions Incomplete/Unclear Part Lost/Missing Wrong Stock Pulled Burrs Cuffs Contamination Maintenance Part Moved Mislabeled Positioned Wrong **Heat Treat** Countersink Cut Too Short Misread Other Inspection Strip in Tube Power Loss/Surge Drill Holes Ripples in Bend Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Wave/Twist in Tube Folio Outside Dimensions

**FAULT CATEGORY** 

General

Supplier Training Unapproved

**Landing Gear** 

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	95834
Description: Step Leg	Part Number:	D3065-5
Inspection Dwg: D3065 Rev: B		Page 1 of 1

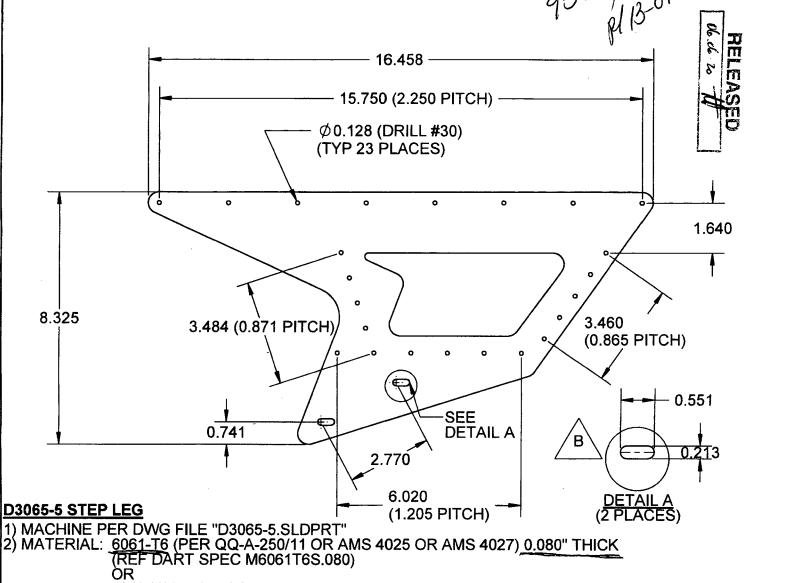
## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
Dimension		Dimension			mspection	
16.458	+/-0.010	16.458			LT	Jkmo6
15.750	+/-0.005	15,750"	_		1	
2.250	+/-0.005	2.2535	_		V	
3.460	+/-0.005	3.462"			V	
0.865	+/-0.005	0.867	-		U	
6.020	+/-0.005	6.0234	_		ν	
1.205	+/-0.005	1,2091	-		V	
3.484	+/-0.005	3.487"	-		V	
0.871	+/-0.005	0.873"	_		V	
8.325	+/-0.010	8.329"	-		V	Produtoa
0.551	+/-0.010	0.554	-		ν	
0.213	+0.005/-0.000	0.214"	_		V	
Ø0.128	+0.005/-0.000	0.139"	-		V	
*******						
11.						
7.00						

Measured by: Jm	Audited by:	Prototype Approval:	N/A
Date: 13-2-26	Date: パンフラウ	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	03.09.22	New Issue P/O D3065-041	KJ/RF	
В	04.06.15	Added Ø0.128 dimension	KJ/JLM 14	
С	06.06.23	Dwg Rev. changed	KJ/JLM 🛠	SU11



5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
4) BREAK ALL SHARP EDGES 0.005 TO 0.010
5) TOLERANCES ARE PER DART QSI-018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

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BY DART AEROSPACE LTD

SCALE 1 1:3	STEP LEG ASSEMBLY	06.05.23	DATE 06.0
REV. B SHEET 4 OF 5	DRAWING NO. D3065	APPROVED	CHECKED $\rho_H$
E LTD	DART AEROSPACE LTI HAWKESBURY, ONTARIO, CANADA	DRAWN BY	$\psi$